

AsAP please

Work Order ID 64266

December 1, 2010 10:55:21 AM



Page 1

Item ID: D3122-1

Revision ID:

Item Name: Lever

Start Date: 12/01/10 Start Qty: 4.00

Required Date: 12/03/10 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

*U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

D3122

Revision Nbr

Rev *A1*

*see attached email from DS*

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3122

Dwg Rev: *A1*

Prog Rev: *A1*

2-

Deburr if necessary

*304 176*

*B10-12-2*

*(4)*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*B10-12-2*

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*- inspect to spec*

*A1 Dwg*

*2012/02*

*(18)*

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Page 2

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Accept

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

*12/1/10*

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*12/1/10* *(4)*

*10/12/02*

*10-12-02*

# Picklist Print

December 1, 2010 10:55:20 AM

Page 1

Work Order ID: 64266

Parent Item: D3122-1

Parent Item Name: Lever



Start Date: 12/01/10

Required Date: 12/03/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A: 04.11.29 (New issue: KJ/RF)  
IPP Rev B: New dwg rev. ecn781 06.04.18 EC  
IPP Rev: C Now on Waterjet 09-01-06 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	22.0003	0.0233	0.098105			



304/316 0.125 Sheet



1310-12-2

Location

Loc Qty

Loc Code

MAT

22.0003

114799

22.0003

114799

(4)

## FIRST ARTICLE INSPECTION CHECKLIST

## Prototype

H:\FORMS\Quality Assurance\approved QA\FAI revD



SUPERCEDED BY

Rev. B 04.11.24

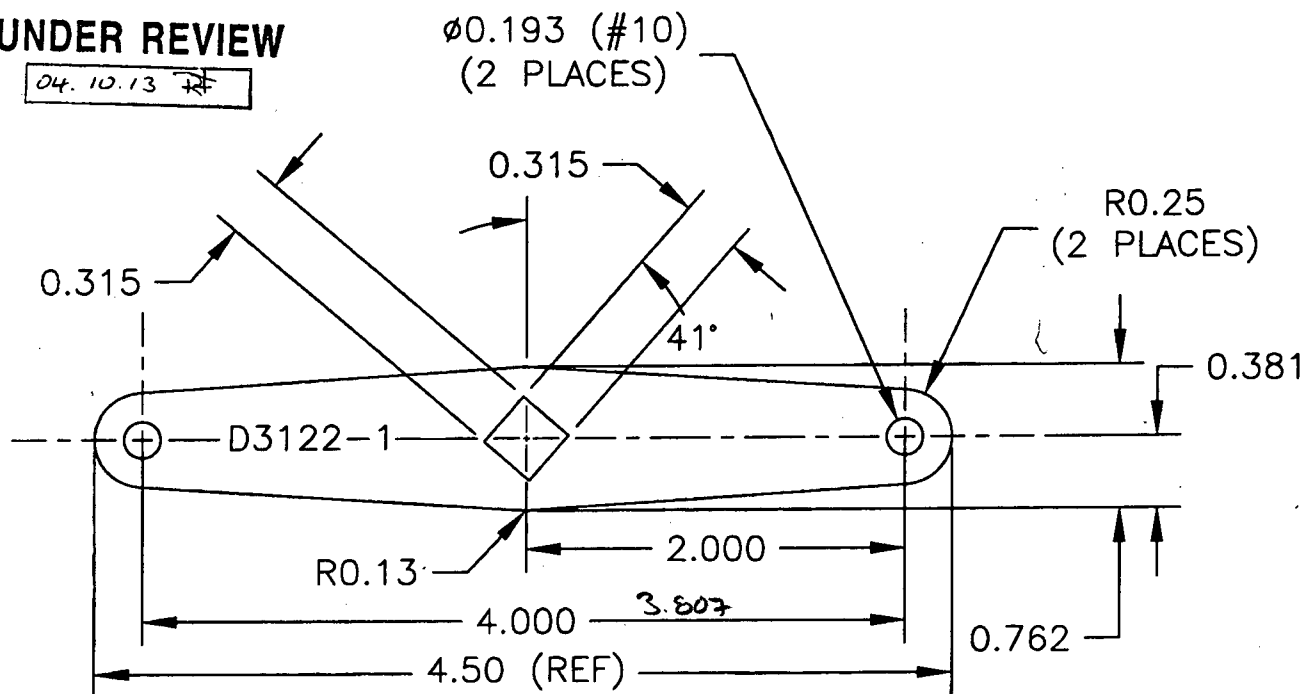
RELEASED  
02.05.27



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3122	REV. A SHEET 1 OF 1
DATE		TITLE LEVER	SCALE 1:1
A	02.04.15	NEW ISSUE	
A1	02.09.23	ADD "ANNEALED" SPEC	

UNDER REVIEW

04.10.13



D3122-1 LEVER

REPLACES PREMIER P/N B30-23000-151

W/O 64266

#### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK PER MIL-S-5019  
(REF DART SPEC M304S11) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) MACHINE PER DRAWING FILE "D3122-A1.DWG"
- 6) ENGRAVE/SCRIBE DART P/N AS SHOWN

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**L Lacelle**

**From:** David Shepherd [dshepherd@dartaero.com]

**Sent:** November 30, 2010 3:57 PM

**To:** 'Harvey Siemens'; 'L Lacelle'

**Subject:** RE: Space Door Parts

Harvey,

As discussed, I am OK making D3122-1 to Rev. A1 on a one time basis.

Regards,  
David

**From:** Harvey Siemens [mailto:hsiemens@dartaero.com]

**Sent:** Tuesday, November 23, 2010 1:38 PM

**To:** 'David Shepherd'; 'L Lacelle'

**Subject:** Space Door Parts

David

Linda can't make parts for OLD space doors (from the Premier days) unless you say so. Eagle needs the D3122-1 parts at Rev. A1. The latest Rev parts won't work in their doors. The angle of the square hole and the outer hole spacing is different. (See attachment) Can you give her permission to make those parts?

Let me know if you need/want to discuss.

Regards,

Harvey Siemens

Mechanical Designer

DART Aerospace Ltd.

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12/01/10